

Work Order ID 66427

February 14, 2011 12:43:17 PM



Page 1

Item ID: D2731-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 2/14/11 Start Qty: 34.00

Required Date: 2/25/11 Req'd Qty: 34.00

Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 1/10/2/14 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2731	Rev C

100 0.00



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut D2423 extrusion to .82"

Batch _____

cut @ meter

CZ 1/10/2/14

110 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per folio FA930

DWG REV: _____

FOLIO REV: _____

issue P10 meter P10:13491

machine as per dwg D2731 REV.C

2-Check for crack while loading into the machine

CZ 1/10/2/14

(34)

Purchasing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2-Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

rec'd + inspect for tire nut damage + attached C of C to W/O

Memo

0.00

11/2/10 39

130

QC6 Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

ml 11-03-10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

ml/AE 11/03/11 32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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Item Name: Mounting Lug

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Cust Item ID:

Required Date: 2/25/11 Req'd Qty: 34.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

M115951

1:50

2:20

32 BL 11-3-14.

160

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

32 d JR 11/03/15

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Packaging

E 4/03/16 (32)

Work Order ID 66427

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Page 4

Item ID: D2731-7

Accept

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Revision ID:

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Item Name: Mounting Lug

Start Date: 2/14/11 Start Qty: 34.00

Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/16
MF
11-03-16

Picklist Print

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Page 1

Work Order ID: 66427

Parent Item: D2731-7

Parent Item Name: Mounting Lug



Start Date: 2/14/11

Required Date: 2/25/11

Start Qty: 34.00

Required Qty: 34.00

Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	507.6914	0.0683	2.444421			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



C 2/11/02/118

Location

Loc Qty

Loc Code

MAT06

507.6914265

43722

180

45800

39.6914265

63005

288

2.45

D2731-7P

Purchased

No

100

Each

0.0000

1

34



LUG



2/4/13/10 (39)

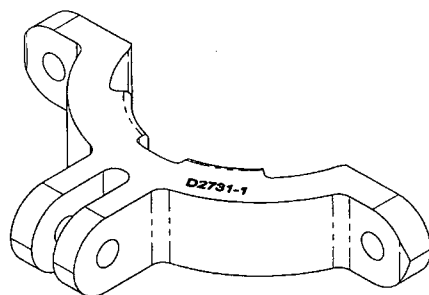
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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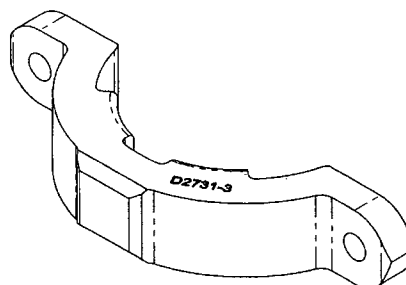
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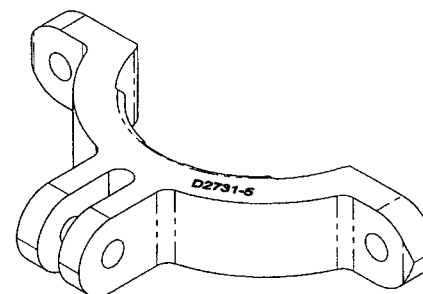
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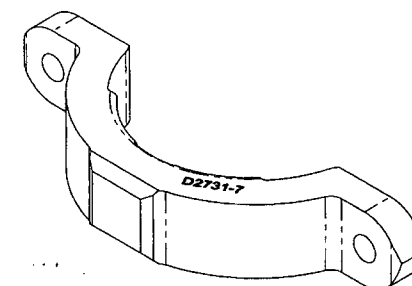
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

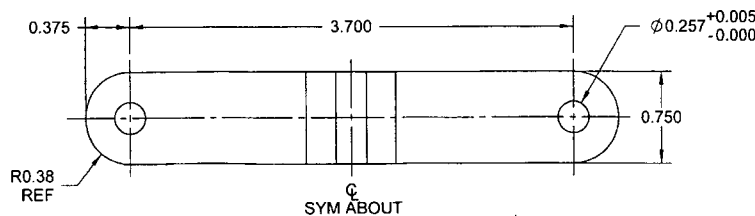
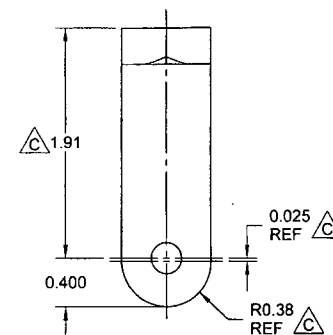
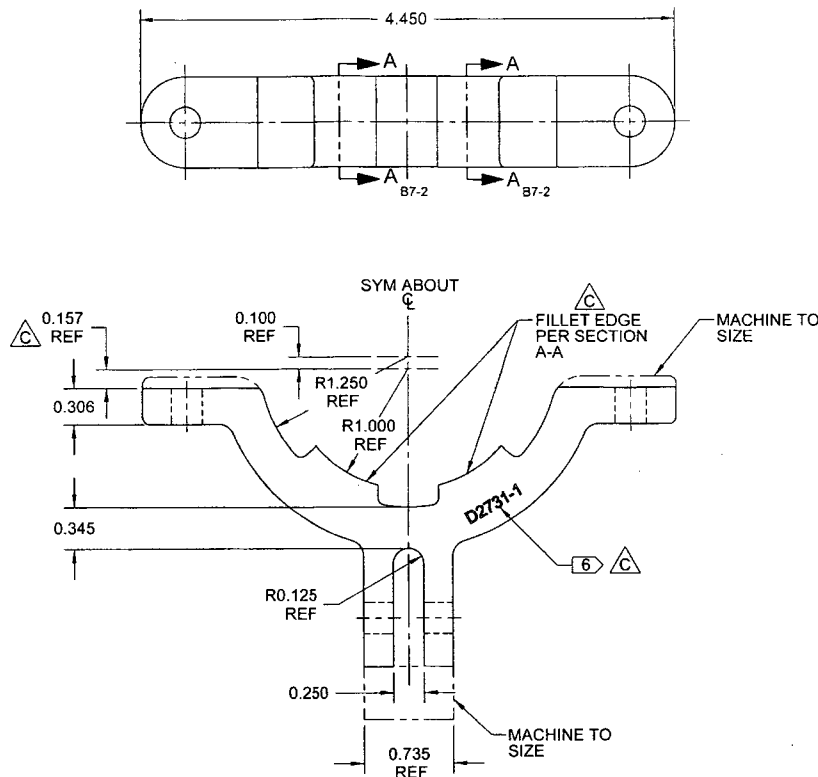
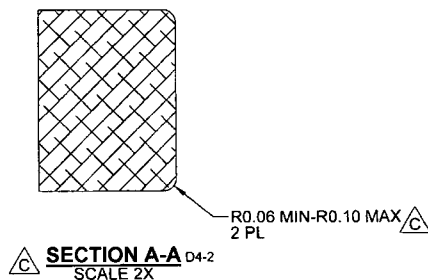
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CL 11/02/14

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09/02/14



C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.05
A	NEW ISSUE	KE	98.05.13
REV	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2731	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
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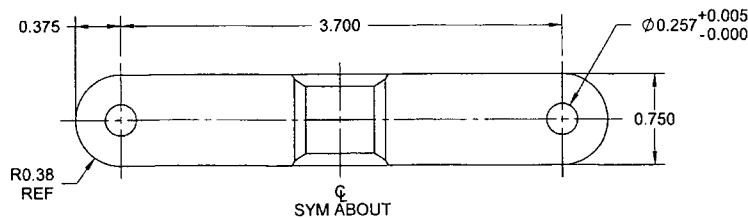
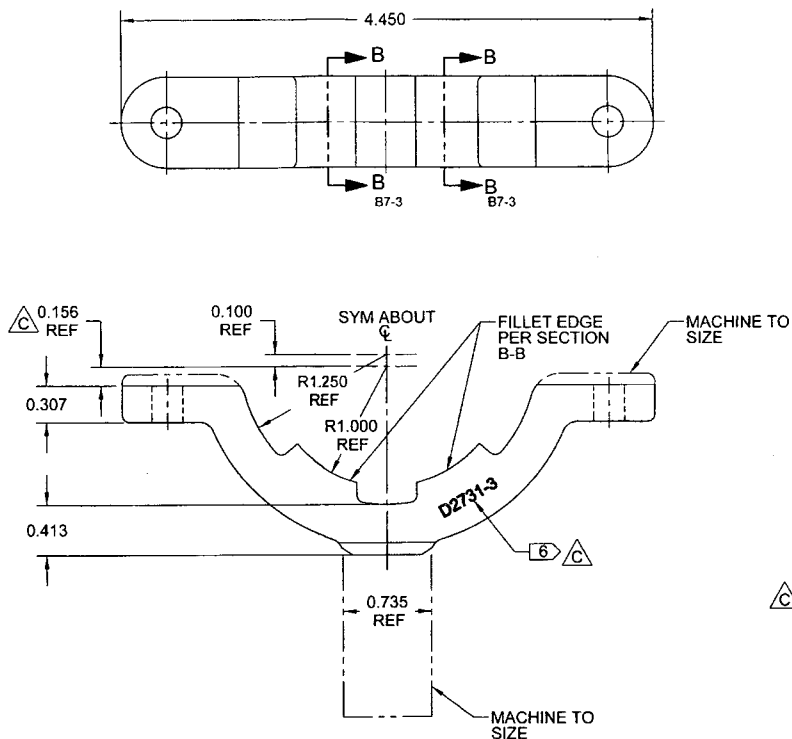
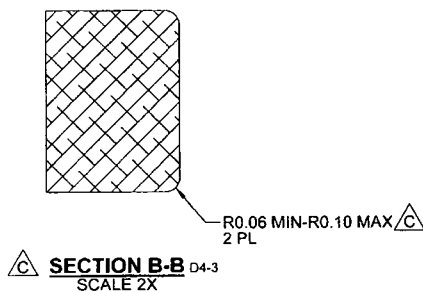


D2731-1 MOUNTING LUG

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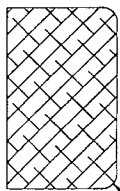


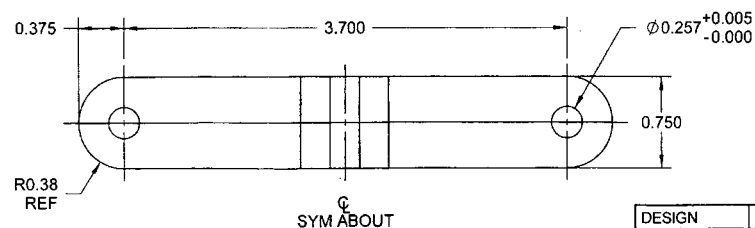
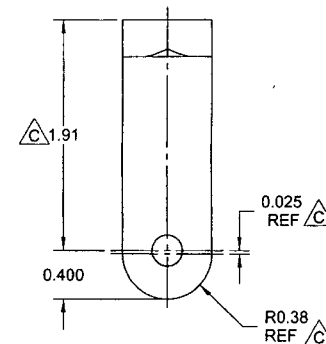
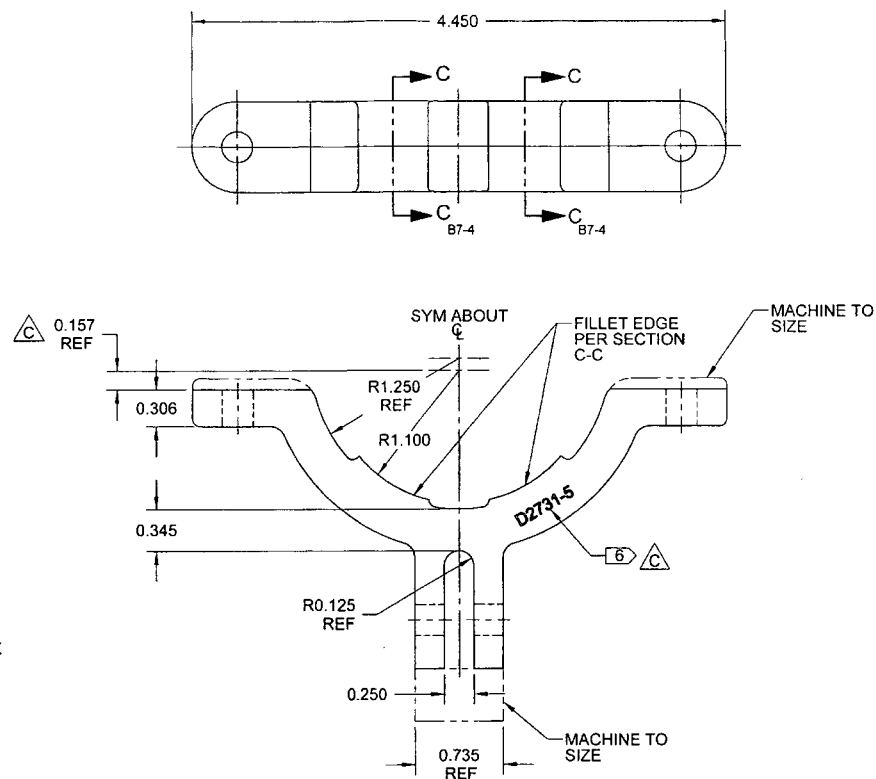
D2731-3 MOUNTING LUG

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R0.06 MIN-R0.10 MAX
2 PL
SECTION C-C D4.4
SCALE 2X

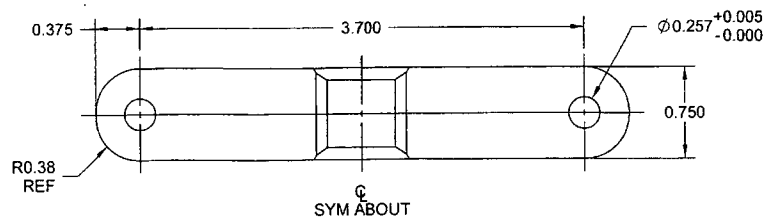
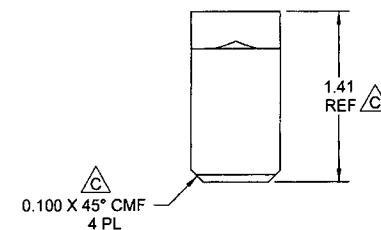
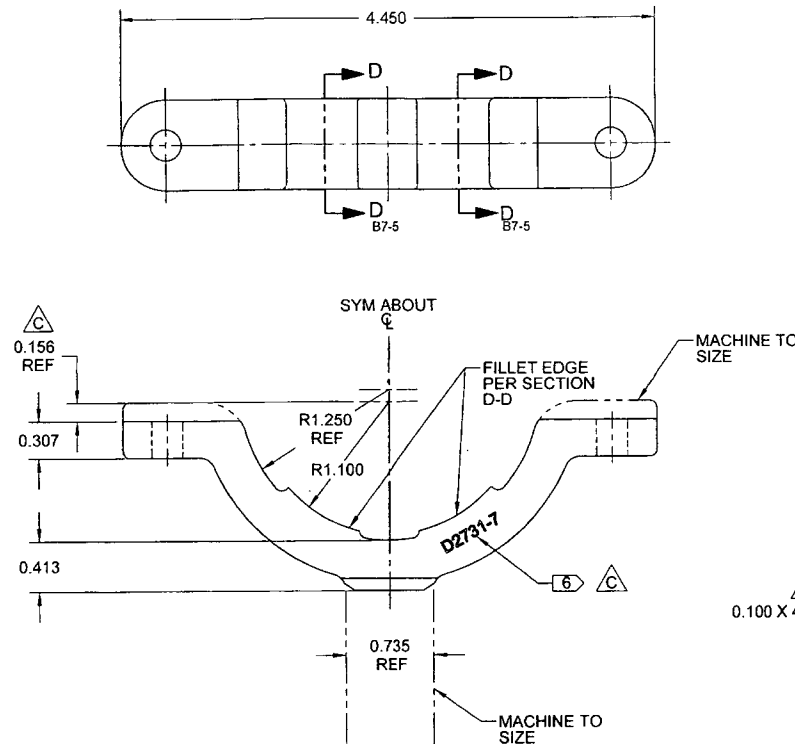
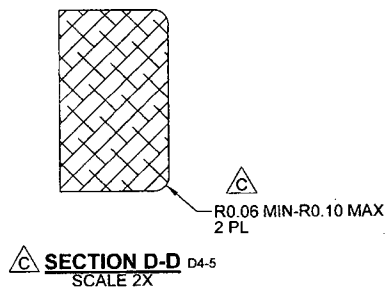


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D2731-7 MOUNTING LUG

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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **17818**

Date:

Mar 09, 2011

Page:

1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13491	Sold By:
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG Material supplied by DART: D2423 B45800 for 18 pieces D2423 B63005 for 32 pieces	Each	50 1	50 29 C 4/3/11	1
Received by <u>Harry B. [Signature]</u>		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
18	D2731-7	Lug MATERIAL: supplied by DART D2423 B45800	13491
32	D2731-7	Lug MATERIAL: supplied by DART D2423 B63005	13491

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, March 9, 2011